

12/2/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2596
Job Sheet 203982



Part No: D2596

Part Name: Web, 205 Skidtube

Job Qty: 6 pcs



Part Weight: 0 lbs

Job Created: 12/2/19

Due Date: 12/20/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV D IPP: D 99.02.02 Changed QA to QC, Added Step 6 and Cost DM IPP Rev:E 07-07-09
Incorporated DEO 9183 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Skidtubes - 1	6 pcs	12/20/19		0.00	2.85	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	Handfinish - 1-1 Chemical-B4B	6 pcs	12/20/19		0.00	1.57	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		
							Handfinish - 1 - 17 - B4B		

JAN 08 2020



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CANADA
TEL : 1 813 632-5200
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Container No: S245763



Part: D2596

Job No: 203982

Serial No/Batch: S245763

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/08/20

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					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
120 QC 5	6 pcs	12/20/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130 Packaging 3-1 - Stock - B4B	6 pcs	12/20/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	TF
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	6	12/20/19	0.00 0.00	QC 21 - SA - 21	943
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	6

Part Op 100 - 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per
 Descriptions: Dwg D2596 4- Deburr
 110 - (Chemical Conversion Coat per QSI005 4.1)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: 16002)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100	Ext'n - 'I' Beam Web 4"	6 pcs (1 ea)	100-Skidtubes - 1	<u>5166539</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2500-3-100	6	129	0

Part Specifications	
Specifications could not be found.	

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RELEASED
07-06-28

DESIGN PH		DRAWN BY PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H		APPROVED H		DRAWING NO. D2596	
DATE 07.04.17		TITLE 205 WEB		REV. D SHEET 1 OF 1	
A		96.09.16		NEW ISSUE	
B		97.07.23		ø0.63 HOLE WAS ø0.56	
C		98.09.14		INCORPORATED DEO 9097	
D		07.04.17		INCORPORATED DEO 9183	

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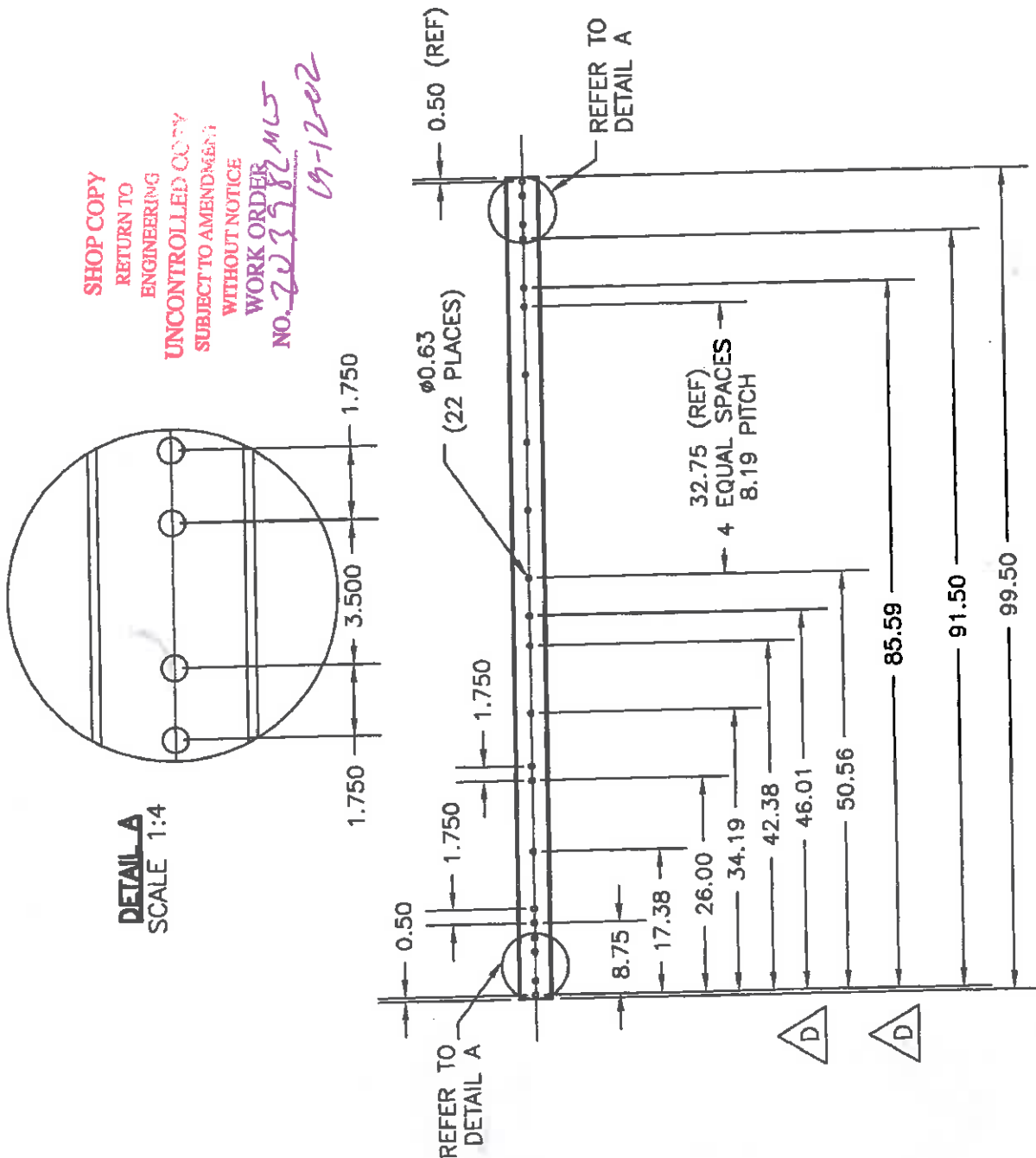
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDERS

NO. 203982 MC

69-1202



D2596 WEB

- | | | |
|----|-----------|--|
| 1) | MATERIAL: | MAKE FROM D2500-3-100 EXTRUSION |
| 2) | FINISH: | CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 |
| 3) | | ALL DIMENSIONS ARE IN INCHES |
| 4) | | TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED |
| 5) | | DEBURR SHARP EDGES 0.010 TO 0.020 |

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By		Lead hand / Supervisor	
Root Cause		Fault Category		Other/Details:		QC / QA Coordinator	
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	